Work Order ID 119497

Friday, May 16, 2014 12:52:20 PM

119497

Item ID: D4182-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fitting, Quick Disconnect

Start Date: 5/15/14 **Start Qty:** 5.00 *5*

Required Date: 5/15/14 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 14-05-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D4182	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	PURCHASING	0.00							
100									
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 24325 Purchase Part Number: P/N 6718K52 Supplier: MCMASTER CARR Material release note is required.								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	**Memo**	0.00							
Packaging	Ensure material release note is attached								

CL 14/05/23 5

14/05/26 (5)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 119497

119497

Friday, May 16, 2014 12:52:20 PM

Item ID: D4182-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fitting, Quick Disconnect

Start Date: 5/15/14 **Start Qty:** 5.00 *5* **Cust Item ID:**

Required Date: 5/15/14 **Req'd Qty:** 5.00 *5* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				5			
120 QC Quality Control	**Memo**	0.00 14 5 27							
130	Identify as per dwg & Stock Location: STO98	0.00							
130 Packaging Packaging	**Memo**	0.00				5x		14-5-27	DAS 9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	**Memo**	0.00							

14-05-27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

Friday, May 16, 2014 12:52:24 PM

Work Order ID: 119497

119497

Parent Item: D4182-1

D4182-1

Parent Item Name: Fitting, Quick Disconnect

Start Date: 5/15/14 **Required Date:** 5/15/14

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP Rev:A 10.10.05 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6718K52		Purchased	No			110	Each	0.0000	1	5			
6718K52									**				
Fitting, Quick Disconnect													

5/14/26 (5)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

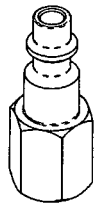
Landing Gear

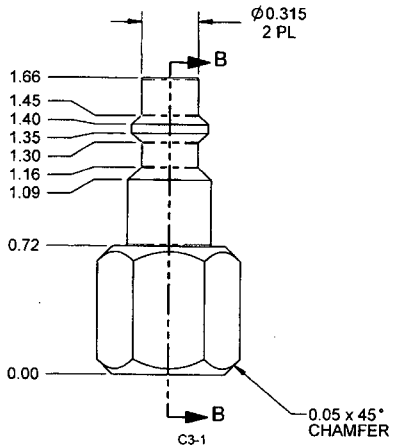
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

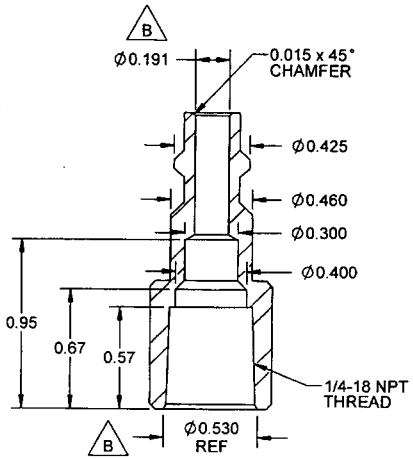
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

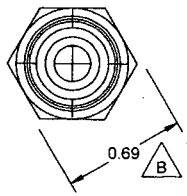
SPECIFICATION CONTROL DRAWING







SECTION B-B C6-1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119497 MLJ
14-05-22

RELEASED
2011-06-30

D4182-1 FITTING, QUICK DISCONNECT

NOTES:
1) MATERIAL: STAINLESS STEEL
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.07 lbs
8) POSSIBLE SUPPLIER: McMASTER CARR P/N 6718K52

REV.	DESCRIPTION	BY	DATE
B	Ø0.191 WAS Ø0.201 (ZN D4-1); 0.57 WAS 0.45 (ZN C4-1); 0.69 WAS 0.62 (ZN B5-1)	RF	11.03.07
A	NEW ISSUE	RF	10.09.16

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. DSC-D4182	REV. B
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE FITTING	SCALE NTS
DE APPR.			
DATE	11.03.07		

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24325

Purchase Order Date 5/23/2014
PO Print Date 5/23/2014

Order From : VU-MCM001

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie		
Vendor Phone	330 995 5500	**Customer POID**			
		Customer Tax #	10127-2607		
Ship To Contact		**Terms**	Net 10		
Ship To Phone		**Currency**	USD		
Ship Via:	FedEx PI collect	**FOB**	FCA – (Free Carrier)		
Ship Acct:					

3	6718K52	Fitting, Quick Disconnect	5/28/2014 Yes 5/28/2014	5.00 Each		$5.64	$28.20
	AS PER DWG D4182 REV. B B119497						
					Line Total:		**$28.20**
4	95606A170	Washer	5/28/2014 Yes 5/28/2014	100.00 Each		$0.10	$10.14
	AS PER DWG D3631 REV. A B119553						
					Line Total:		**$10.14**
5	92311A639	SS SET SCREW	5/28/2014 Yes 5/28/2014	100.00 Each		$0.64	$63.60
	AS PER DWG D2747 REV. B B119525						
					Line Total:		**$63.60**

Note:

McMASTER-CARR®

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO24325

Order Placed By
Chantal Lavoie

05/23/2014

McMaster-Carr Number
4252943-02

LNS **A11**

Line	Description	Ordered	Shipped	
2	**91343A100** Type 316 Stainless Steel Serrated-Flange Hex Locknut, 1/4"-20 Thread Size, 7/16" W, 15/64" Overall Height, Packs of 10 Your Part Number: **D2484P** Unit Price: $3.83 Extended Price: $19.15	**5 Packs**	**5**	2 - 701 - 07 25 - 03 A100 5PK 2
5	**92311A639** 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Unit Price: $6.36 Extended Price: $63.60	**10 Packs**	**10**	2 - 695 - 07 26 - 02 A639 10PK 5
3	**6718K52** Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size Unit Price: $5.64 Extended Price: $28.20	**5 Each**	**5**	2 - 270 3

Dart Aerospace Ltd

EXP
INV

4
5 lir

Sm
13x8x4

FW1WBF
05/23/20
11:37/12
722
Cycle 44

1141132642316